



T H E H A R R I S P R O D U C T S G R O U P
A L I N C O L N E L E C T R I C C O M P A N Y
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TECHNICAL SPECIFICATION SHEET

STAY CLEAN® PASTE SOLDERING FLUX

FLUX PROPERTIES:

Designed primarily for copper to copper and copper to brass connections the paste form is ideal for soldering tube joints. Not recommended for electrical or electronic applications due to the potential corrosive residue of the flux. Stay Clean Paste flux works well with most leaded and lead-free solder compositions. Flux residue should be removed after soldering.

MINIMAL COMPOSITION

Ethylene Glycol	2-15%	Petrolatum	30-80%
Ammonium Chloride	1-10%	Water	1-10%
Zinc Chloride	5-30%		

Physical Properties:

Specific Gravity @ 70°F (21°C)	1.11	Reid Vapor Pressure (psig) @ 100°F (38°C)	.1
Density	1.106	Effective Temp. Range	Up to 600°F

AVAILABLE FORMS:

4 oz. brush cap	24/case
1 # tub	12/case

SPECIFICATION COMPLIANCE:

Meets Commercial Specification A-A51145C Type 1 Form A

WARNING: PROTECT yourself and others. Read and understand this information.

FUMES AND GASES can be hazardous to your health. Burns eyes and skin on contact.

CAN BE FATAL IF SWALLOWED

- Before use, read and understand the manufacturer's instructions, Material Safety Data Sheet (MSDSs), and your employer's safety practices.
- Keep your head out of fumes.
- Use enough ventilation, exhaust at the flame, or both, to keep fumes and gases from your breathing zone and the general area.
- Avoid contact of flux with eyes and skin.
- Do not take internally.
- Keep children away when using
- See American National Standard Z49.1, *Safety in Welding, Cutting, and Allied Processes*, published by the American Welding Society, 550 N.W. LeJeune Road, Miami, Florida 33126; OSHA Safety and Health Standards, available from the U.S. Government Office, Washington, DC 20402

First Aid: If contact in eyes, flush immediately with water for 15 minutes. If swallowed, induce vomiting. Never give anything by mouth to an unconscious person. Call a physician.

STATEMENT OF LIABILITY- DISCLAIMER

Any suggestion of product applications or results is given without representation or warranty, either expressed or implied. Without exception or limitation, there are no warranties of merchantability or of fitness for particular purpose or application. The user must fully evaluate every process and application in all aspects, including suitability, compliance with applicable law and non-infringement of the rights of others. The Harris Products Group and its affiliates shall have no liability in respect thereof.

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